

## 2-sided Wood Inserts L50

A09-900

The cycle time for a 2-sided reversible knife includes handling - loading and rotating - as well as the grinding of the 2 sides. To keep the time low grinding and handling operations have been optimized to a minimum of movements and the usage of one single wheel, which allows to grind the 45° clearance in one pass.



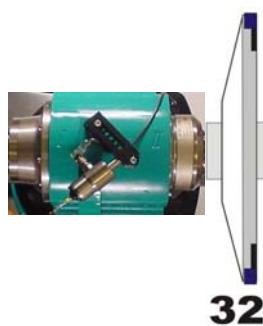
### 1. Cycletime for Production

Tool specifications from rectangular blank 50x14 Material CARBIDE				
Operations	1st side	Rotate tool	2nd side	Loading
Feed [mm/Min]	500	2000	500	2000
Power [kW]	1		1	
Cutting feed [m/s]	34		34	
Used wheels				
Grinding time [s]	32		32	
Total cycle time	0 Min 47			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

32 Ø250 12C9 D64



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM, STL 650  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 4.3

responsible engineer: KOC, 122.8.08

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